

Date: Monday, 16/03/2009 9:16:54 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EC 135 SKIDTUBE ASSEMBLY
Job Number : 46501	
Estimate Number : 12472	
P.O. Number :	Part Number : D135751011
This Issue : 16/03/2009 S.O. No. :	Drawing Number : D3507 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : C
Previous Run : 46500	Material :
Written By :	Due Date : 31/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09-03-16</u>	
Comment : Est Rev:A 06-06-21 New Issue JLM Est Rev:B 06-12-18 As per Rev B JLM Est Rev:C 07-12-11 ECN 1036 as per revB DD Est Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: HJ for JUD 09/04/09

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

Handwritten: 509/04/09

2.0	D2962150	3.540 Outer Tube, Extrut
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

Extrusion

Handwritten: B28672

Handwritten: DP

Handwritten: 9-3-16

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

Handwritten: MB

Handwritten: 09-03-16

Handwritten: ①

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------

**Comment:** BENDING MACHINE

Bend tube as per program

on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

Handwritten: MB 09-03-16

Handwritten: ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

2-Cut Aft end at VC using DT8185

3-Deburr ends

4-Drill Aft & Fwd Cap holes using DT8678

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with 3/16 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using 3/16" drill. ****DO NOT OPEN AFT CAP HOLES*****

7-Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

9-Open holes section C-C to .375" and locate DT9431 using "T" pin & cleco.

10- Drill holes section G-G (DT9431)

11-Open Aft & Fwd Cap holes using .208" drill.

12-Bore out aft end of tube as per Dwg D3507 & Detail "B".

13-Open ground wire hole .297" section E-E

14-Deburr holes.

MA-3-17

MA 9-3-17

BE 9-3-17

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 9-3-23

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MA 09-03-23

W/O:		WORK ORDER CHANGES					
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Job Number: 46501

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① M 9-3-23

9.0

D35043

Crossbolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSBOLT SPACER

Batch:

B 31232 B 28034

BE 9-3-24

10.0

D35041

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

Batch:

B 31234

BE 9-3-24

11.0

D35051

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Batch:

B 41604

pm 09-03-23

12.0

D35061

Doubler



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

DOUBLER

Batch:

B 46538

BE 9-3-24

13.0

D35063

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

Batch:

B 46539

BE 9-3-24

14.0

D35045

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

batch

B 36181

BE 9-3-24

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 46501

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS20601AD4W3

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch:

107823 (15R) BE 9-3-24

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex

Batch: m111081

Exp Date: 10/01/01

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD

Batch: m109213

BE 9-03-24

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

m' 9-03-23

3 BE 9-03-24

Tools: E

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 09-03-24

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507.

BE 9-03-24

W/O:		WORK ORDER CHANGES					
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Job Number: 46501

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/24 @

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HL

09-04-02

(XU)

21.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M11089

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

HL 09-04-2

(1)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-06

(X1)

23.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M1108606

HL

24.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: M119393

HL

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

HL

09-04-06

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 46501

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

6 09/04/06 H

27.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 11108062

HL

X

28.0

D29653

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B416582

HL

29.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B346790

HL

30.0

D35081

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B342973

HL

31.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B342250

HL

32.0

D35085

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B342251

HL

09-04-06 H

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 46501

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D35087

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 1331198

JK

34.0

D35581

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342533

JK

35.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1345661

JK

36.0

D35585

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1343244

JK

37.0

D35587

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1343245

JK

38.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: M110715

JK

39.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: M1106513

JK

09-04-06

JK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 46501

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

~~NAS1611007~~

O-RING



N/A

ll



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

O-RING

batch:

plugs already have o-rings

41.0

D3492041

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

PLUG ASSEMBLY

Batch: 1343816

ll

42.0

D3492043

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

PLUG ASSEMBLY

batch 1345339

ll

43.0

D3492047

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PLUG ASSEMBLY

Batch: 1328961

ll

44.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total: 33.0000 Each(s)

Washer

Batch: M110876

ll

45.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total: 31.0000 Each(s)

BOLT

Batch: M111279

ll

46.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M110916

ll

09-04-06 CXL

W/O:		WORK ORDER CHANGES					
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Job Number: 46501

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M 111087

Exp Date: 10/20

3-Install Wearplates as per Dwg D3507,

✓ Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Screws where indicated on Dwg(Note #6)

A/R 241 Sika Flex Batch: M 111087

Exp Date: 10/20

✓ 4-Install Plug assemblys as per Dwg D3507.

→ Batch: m 111013.

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

- FL 09/04/07 (1)

48.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/07 (1)

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

50.0

D35121

Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WEARPLATE

Batch: 44642

09/04/09 (1)

51.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M109632

09/04/09 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 46501

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

BATCH:

M11193

SS 09/04/09 (X)

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/04/09 (X)

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751-011

Location:

PPP Rev:

82
9/4/9

(15)

SP

55.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14 (X)

Job Completion



4 09.04.09

B 46501

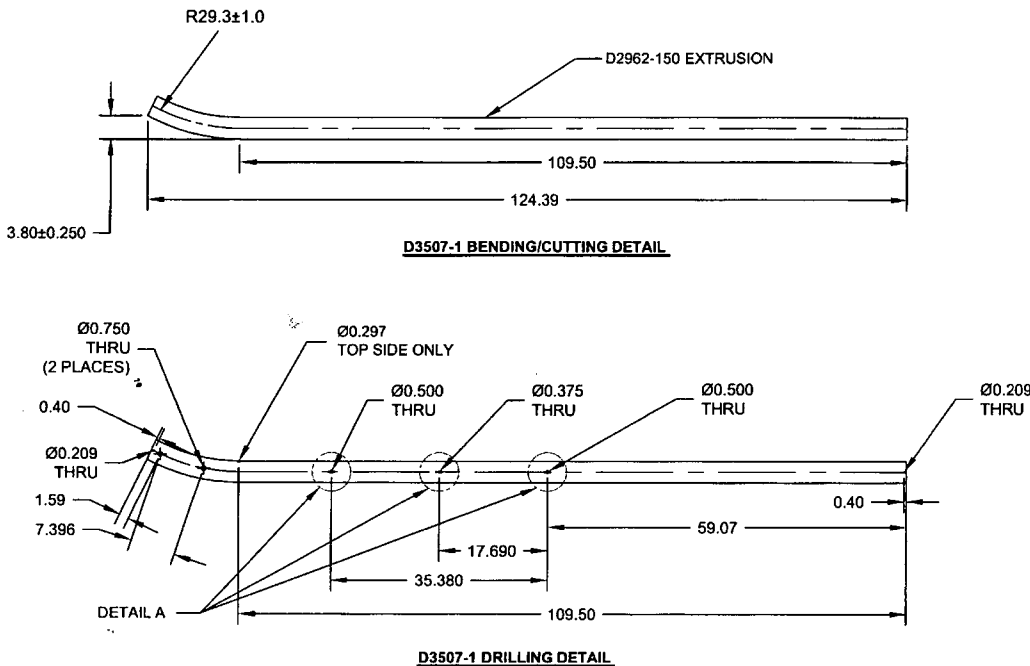
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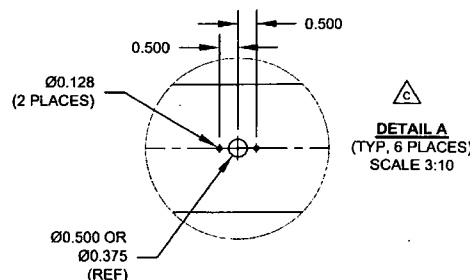


Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4.
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JIC		
CHECKED	PH		
MFG. APPR.	EC		
DE APPR.	PH		
DATE	07.09.19	DRAWING NO.	REV. C
		D3507	SHEET 1 OF 2
		TITLE	SCALE
		EC 135 SKIDTUBE	NTS
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NO 440501

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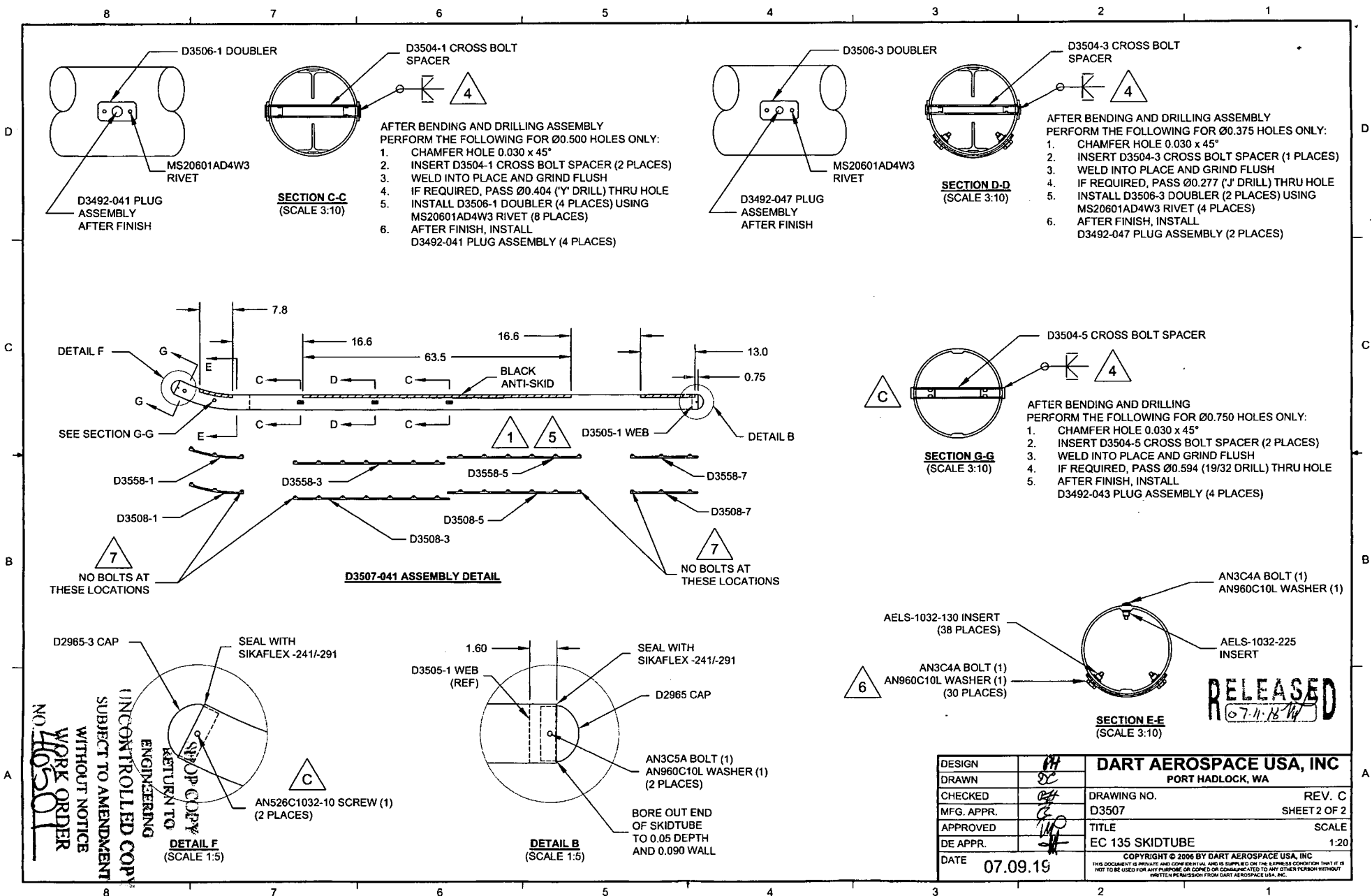
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	PH	DART AEROSPACE USA, INC	
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MFG. APPR.	SC	D3507	SHEET 2 OF 2
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	EC 135 SKIDTUBE	1:20
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 179

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 841333
Part number: 135 751011
Description: SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Lund Date of Test Coupon 08/10/22

Welder Barclay Elliot Date of Test Coupon 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld